

Work Order ID 53028



Page 1

October 22, 2009 10:05:13 AM

Item ID: D3308-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 09/10/22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3308

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3308
Deburr if necessary

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

6061
.063

Deburr = 7mm dia / 11/05

15X

15

18 9-11-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

18 9-11-5

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 50/10/05

4.5

/

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Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	Memo Deburr								
	<i>WAS</i>								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								
	<i>all 09/11/05</i>								
	<i>(15) 8</i>								
150	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								
	<i>mb 09/11/05</i>								
	<i>x15</i>								

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Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/11/9 130 SP

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09

PH 09-11-9
15

Picklist Print

Page 1

October 22, 2009 10:05:17 AM

Work Order ID: 53028



Parent Item: D3308-1RevA



Parent Item Name: Doubler

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	233.2841	0.1977	75		
6061-T6 .063 Sheet												

139-11-5

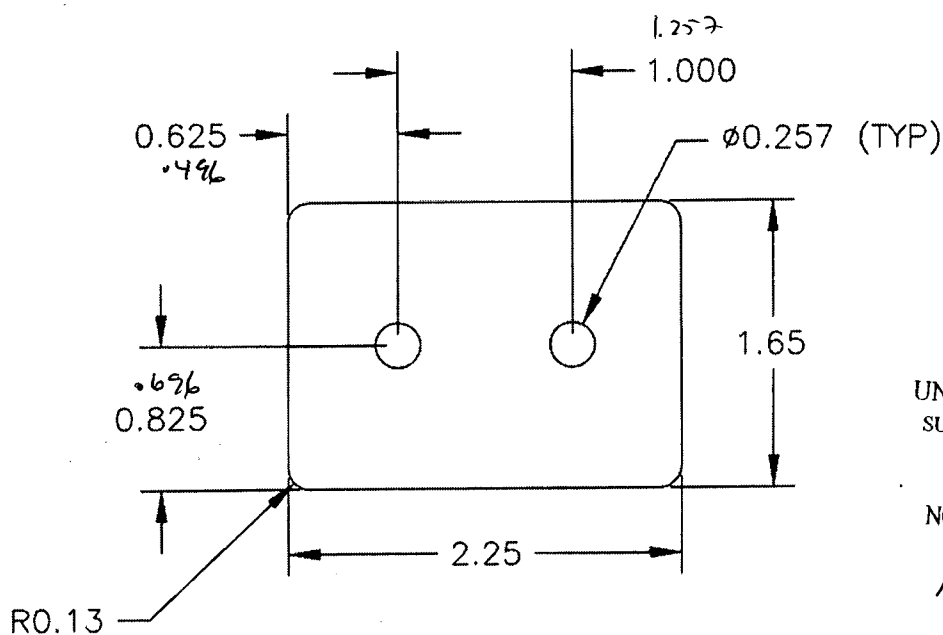
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	233.2841211	
110551	33.2841211	
112939	200	

110551



DESIGN T7	DRAWN BY T7	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3308	REV. A SHEET 1 OF 1
DATE 04.10.13		TITLE DOUBLER	SCALE 1:1
A	04.10.13	NEW ISSUE	

RELEASED
04.11.23



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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53028

BT 09-10-22

D3308-1

D3308-1 NOTES:

- 1) MATERIAL: 6061-T6 SHEET (QQ-A-250/11), 0.063 THICK
(REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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